

Work Order ID 67605

Monday, March 28, 2011 2:28:25 PM



Page 1

Item ID: D3415-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate

Start Date: 3/28/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 11-03-21 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3415	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3415
Deburr if necessary

Dwg Rev B

Prog Rev B 2-

304 .063

11-3-31

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-3-31

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

84104/01

84104/01
x44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1- Deburr 2-C'sink as per Dwg D3415

0.00

0.00

⇒ m-f 11/04/06

(44)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 weeks

counted
(x44)

150



Powdercoat

Powder Coating

White Gloss(Ref:4 3 5.1) per QSI005 4.3-~~Alum~~

Memo

START TIME:

FINISH TIME:

0.00

0.00

OVEN TEMPERATURE:

M116964

Stanless

9:00

9:30

HL. 11-4-11

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

x44 4 24 11/04/11

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut plate as per Dwg D3415

E 11/04/18 (44)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulox 18

(auto)
(44)

W/O:		WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 53

0.00



Packaging

Memo

0.00

Packaging

11/4/19 2 (44)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/19 2

11.04.19

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, March 28, 2011 2:28:31 PM

Page 1

Work Order ID: 67605

Parent Item: D3415-041

Parent Item Name: Nut Plate



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: A 05.10.03 New issue KJ/JLM
IPP Rev:B Now on Waterjet 07-03-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS20427F3-3 *MS 20427F3-3* Purchased



RIVET

Location

Loc Qty

Loc Code

ST322

214

105408

20

17654

194

M304S16GA

Purchased

No

170

sf

4.0000

0.0131

0.330947



304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

4

116623

4

MS21070L4

Purchased

No

170

Each

325.0000

1

24



Inventory

Location

Loc Qty

Loc Code

ST302

325

105878

325

5/11/04/18
718855 (88)

HB11-3-31

116623

(44)

5/11/04/18

44

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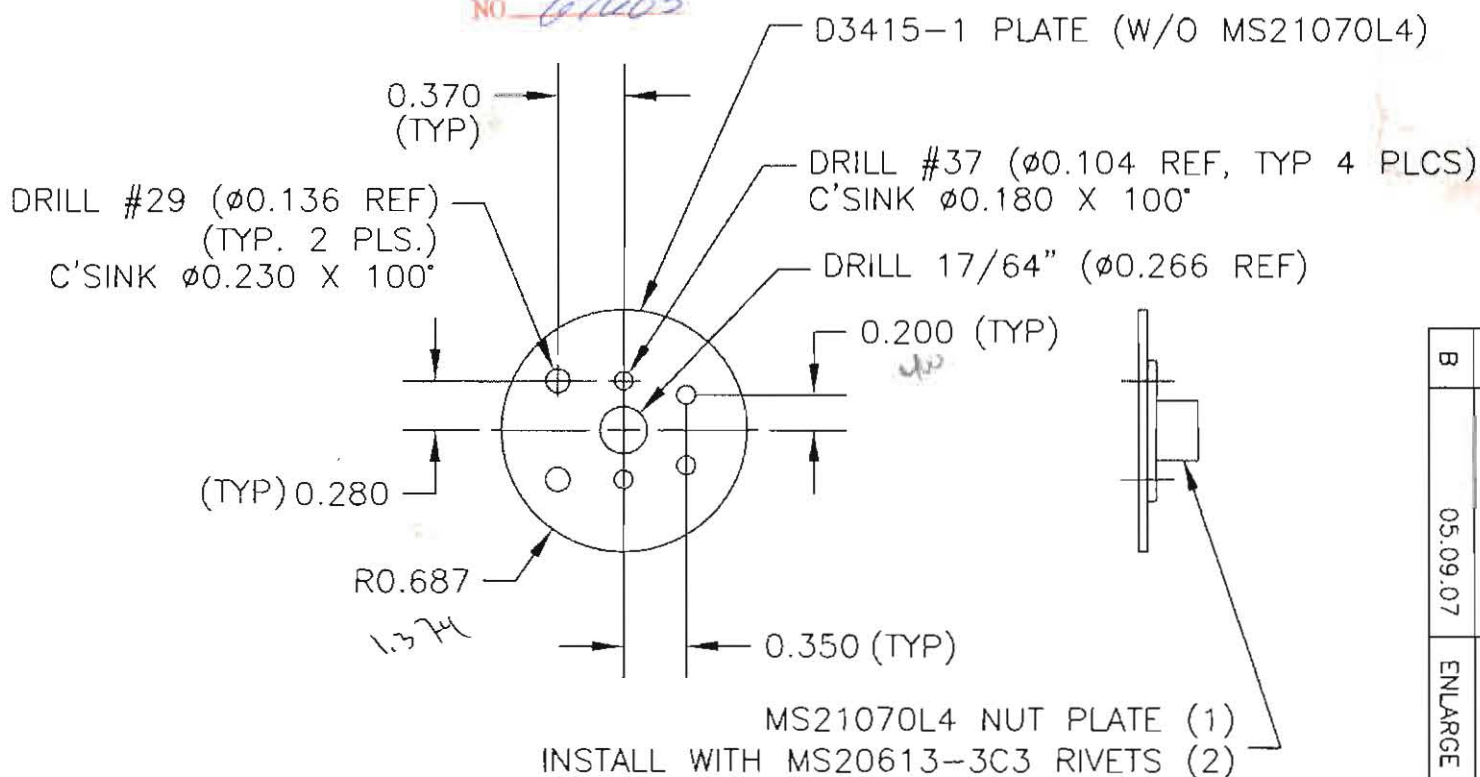
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DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CP	CP	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3415	SHEET 1 OF 1
DATE		TITLE	SCALE
05.09.07		NUT PLATE	1:1
A	05.03.16	NEW ISSUE	
B	05.09.07	ENLARGE ALL HOLES FOR POWDER COAT	



D3415-041 NUT PLATE

- 1) MATERIAL: AISI 304 SS SHEET, 0.063 THICK
(16 GAUGE, REF DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SEE COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67605

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